

Work Order ID 75336

75336

Page 1

October-21-11 7:56:30 AM

Item ID: D3211-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Bracket
Start Date: 20/10/2011 Start Qty: 6.00 *6* Cust Item ID:
Required Date: 08/11/2011 Req'd Qty: 6.00 *6* Customer:
Reference:

Approvals: Process Plan: MLJ Date: 11/10/21 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3211	B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3211 Dwg Rev: B Prog Rev: B 2-

Deburr if necessary

11-10-2911-10-26(6)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

11-10-26

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

5/11/12(46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

6

Cust Item ID:

6

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

130

130

Small Fab

Small Fab

Small Fab

Memo

Deburr

Set Up/ Run Hours

0.00

0.00

Tool ID

Tool #

Plan
Code

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

140

140

Brake NC

Brake NC

NC BRAKE

Memo

Bend D3211-1 Stack as per Dwg D3211

0.00

0.00

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

W/O: 75336		75336 WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3211-13 PAR #: _____ Fault Category: Small FA3 NCR: Yes No DQA: 12/1/11 Date: 12/1/11
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 12/1/11 Date: 12/1/11

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/12/20	140	1 piece crack when it was bend R-C Process	↓ 11.12.20 Q51042	Scrap action No replace	SN 11/12/20	S 11/12/20	↓ 11.12.20 Q51042	S 11/12/20

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 Required Date: 08/11/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									
170	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
170									
Powdercoat	Memo	0.00							
Powder Coating									
180	QC3- Inspect Part Finish	0.00							
180									
QC	Memo	0.00							
Quality Control									

⑥ GF/M/11/12-21
⑤

5x4 M-11/12/21

5 BL 11-12-21

2:45
3200F
FINISH TIME: 3:15
OVEN TEMPERATURE:

M 115128

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>211</u> Memo	0.00 0.00							<u>11/12/28</u>
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>11/12/28</u>

11-12-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

October-21-11 7:56:35 AM

Page 1

Work Order ID: 75336

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Parent Item: D3211-1

D3211-1

Parent Item Name: Bracket

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A

New Issue 05-11-17 JLM

IPP Rev:B

Now on Waterjet 06-10-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	94.5000	1.405	8.873684			

M2024T3S 063

2024-T3 .063 sheet

B11-10-26

Location

Loc Qty

Loc Code

MAT022

94.5

117392

94.5

117392

(6)

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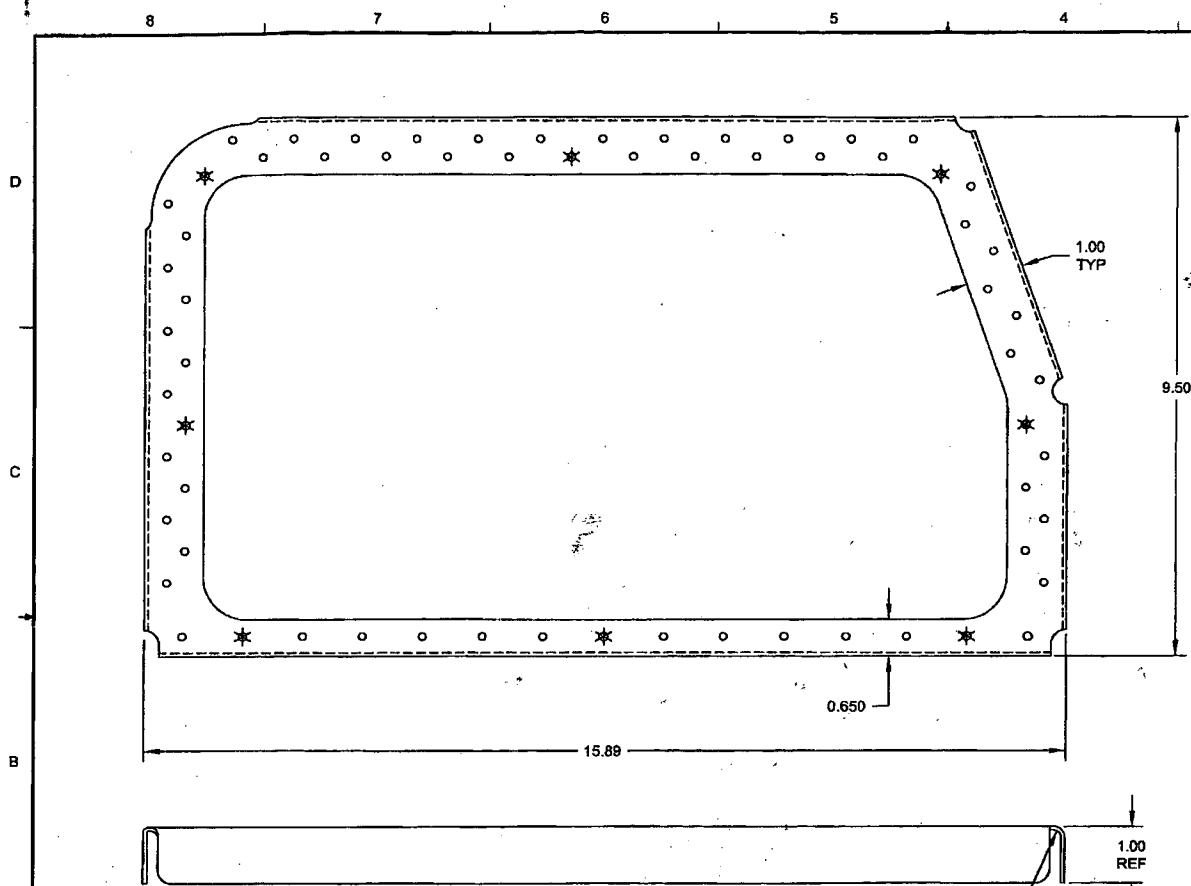
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D3211-1 DOUBLER
(MAKE FROM D3211-1F)
(D3211-1B SIMILAR, MAKE FROM D3211-1BF)

D3211-1/-1B NOTES:

- 1) MATERIAL: MAKE FROM D3211-1F OR D3211-1BF AS APPLICABLE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" AND B/N "BXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.49 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75336 M.L.U.

11/10/20
21

RELEASED
2011-06-14

B	FORMAT TO NEW STD, INCORP. REV. A1 AND DEO: ADDED D3211-1/-1BF. REASON: PAR11-109.	MB	11.06.06
A	NEW ISSUE	CP	03.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3211	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
DATE	11.06.06	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS RELEASED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

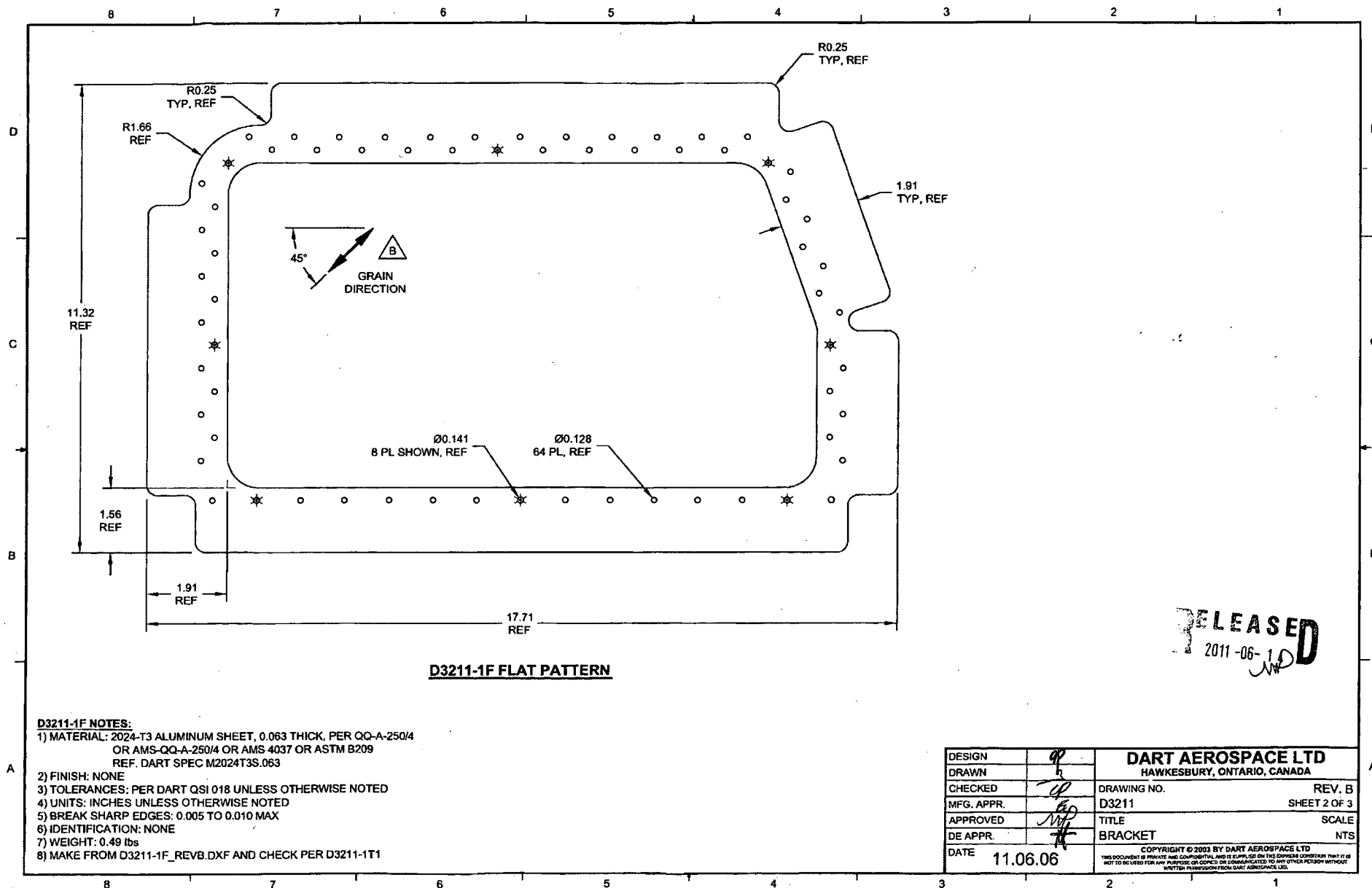
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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RELEASED
2011-06-10

D3211-1F NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF. DART SPEC M2024T3S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.49 lbs
- 8) MAKE FROM D3211-1F_REV8.DXF AND CHECK PER D3211-1T1

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3211	SHEET 2 OF 3
APPROVED		TITLE	SCALE
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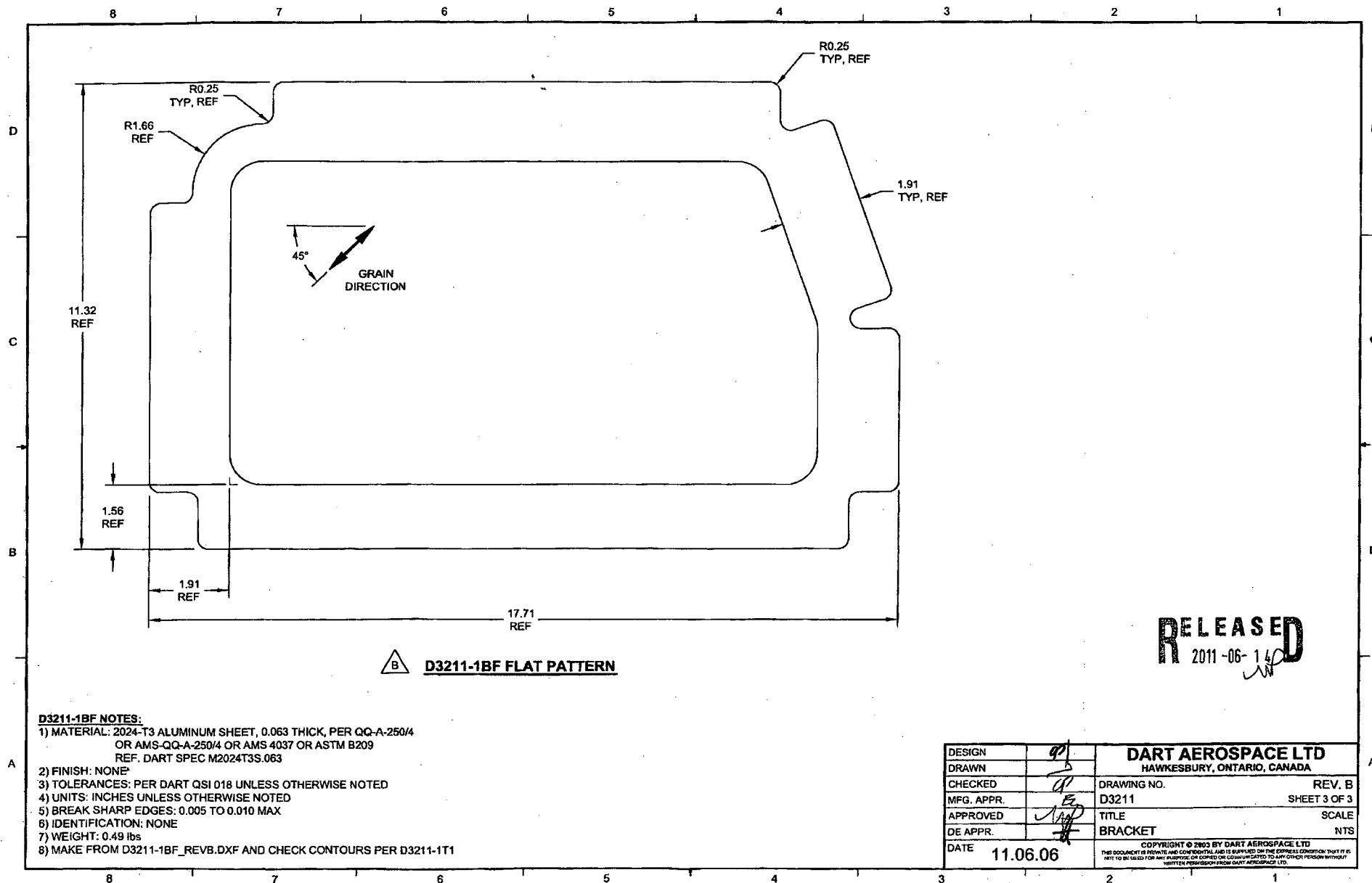
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
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